



Dart Aerospace Ltd.
1270 Aberdeen St
Hawkesbury, ON
K6A 1K7
Canada

Tel (613) 632-5200
Fax 613 632-5246

D3145-2
Job Sheet 210045



Part No: D3145-2

Job Qty: 4 pcs

Part Name: Bracket



Part Weight: 0 lbs

Status: New

Priority: Medium

Job Created: 5/22/20

Job Tracking No:

Due Date: 6/10/20

Created By: Marie Lajeunesse

Type: Stock

Description:

Note: DWG REV B IPP A 03.02.28 New issue KJ/RF

Ship Via:

Bill of Materials

Job Routing

Op No	Operation	Qty	Start Date	Due Date	Standard		Workcenter/Supplier		Sign-off
					Setup Hrs	Run Hrs	Workcenter / Supplier	Lead Time	
100	Bandsaw - 1	4 pcs		6/9/20	0.00	0.40	Bandsaw - 1		lt 20-05-27
110	HAAS 4 Axis - B4B	4 pcs		6/9/20	1.00	12.50	HAAS - 1 - B4B		
							HAAS - 2 - B4B		
							HAAS - 3 - B4B		
							HAAS - 4 - B4B		OK/B 20-05-31
120	QC 2	4 pcs		6/9/20	0.00	0.00	QC 2 - 1		
							QC 2 - 12		
							QC 2 - 14		OK 20/06/02
							QC 2 - 17		
							QC 2 - 19		
							QC 2 - 2		
							QC 2 - 20		
							QC 2 - 22		
							QC 2 - 23		
							QC 2 - 25		
							QC 2 - 32		
							QC 2 - 33		
							QC 2 - 35		
							QC 2 - 39		
							QC 2 - 4		
							QC 2 - 40		
							QC 2 - 44		
							QC 2 - 45		
							QC 2 - 48		
							QC 2 - 49		
							QC 2 - 50		
							QC 2 - 51		
							QC 2 - 52		
							QC 2 - 57		
							QC 2 - 62		



Container No: S279795



Part: D3145-2

Job No: 210045

Serial No/Batch: S279795

Revision:

Inspector:

Exp Date:

Instructions: Various STC's

Dart Aerospace Ltd.
1270 Aberdeen Street
Hawkesbury, ON K6A 1K7
CANADA
TEL: 1 613 632-5200
Email: sales@dartaero.com
www.dartaerospace.com

Date: 05/27/20

Plex 5/22/20 12:51 PM Dart.lajeunesse.marie

					QC 2 - 63	
					QC 2 - 8	
					QC 2 - 66	
					QC 2 - 64	
					QC 2 - 65	
					QC 2 - 5	
					QC 2 - 71	
					QC 2 - 73	
					QC 2 - 69	
					QC 2 - 76	
					QC 2 - 86	
					QC 2 - 83	
					QC 8 - 12	
					QC 8 - 14	
					QC 8 - 17	
					QC 8 - 20	
					QC 8 - 25	
130 QC 8	4 pcs	6/9/20	0.00	0.00	QC 8 - 3	
					QC 8 - 32	
					QC 8 - 33	
					QC 8 - 35	
					QC 8 - 39	
					QC 8 - 4	
					QC 8 - 44	
					QC 8 - 45	
					QC 8 - 49	
					QC 8 - 58	
					QC 8 - 8	
					QC 8 - 9	
					QC 8 - 68	
					QC 8 - 67	
					QC 8 - 1 (A)	
					QC 8 - 47	
					QC 8 - 40	
					QC 8 - 52	
					QC 8 - 23	
					QC 8 - 57	SBC 20/06/02
					QC 8 - 76	
					QC 8 - 61	
					QC 8 - 66	
					QC 8 - 73	
					QC 8 - 82	
140 Handfinish - 1-1 Chemical-B4B	4 pcs	6/9/20	0.00	0.27	Handfinish - 1 - 1 - B4B	BEB20-06-03
					Handfinish - 1 - 2 - B4B	
					Handfinish - 1 - 3 - B4B	
					Handfinish - 1 - 4 - B4B	
					Handfinish - 1 - 5 - B4B	
					Handfinish - 1 - 6 - B4B	
					Handfinish - 1 - 7 - B4B	
					Handfinish - 1 - 8 - B4B	
					Handfinish - 1 - 9 - B4B	
					Handfinish - 1 - 10 -	
					Plex 5/22/20 12:51 PM Dart.lajeunesse.marie	

						B4B	
						Handfinish - 1 - 11 - B4B	
						Handfinish - 1 - 12 - B4B	
						Handfinish - 1 - 13 - B4B	
						Handfinish - 1 - 14 - B4B	
						Handfinish - 1 - 15 - B4B	
						Handfinish - 1 - 16 - B4B	
						Handfinish - 1 - 17 - B4B	
						Handfinish - 1 - 18 - B4B	
						Handfinish - 1 - 19 - B4B	
						Handfinish - 1 - 20 - B4B	
						Handfinish - 1 - 21 - B4B	
						Handfinish - 1 - 22 - B4B	
150	Powdercoat - 1 White GI(A)- B4B	4 pcs	6/10/20	0.00	0.80	Powdercoat - 1 - B4B	
						Powdercoat - 2 - B4B	
						Powdercoat - 3 - B4B	20-06-3
						Powdercoat - 4 - B4B	
160	QC 3	4 pcs	6/10/20	0.00	0.00	QC 3 - 10	
						QC 3 - 13	
						QC 3 - 15	20-6-3
						QC 3 - 17	
						QC 3 - 18	
						QC 3 - 2	
						QC 3 - 28	
						QC 3 - 3	
						QC 3 - 30	
						QC 3 - 34	
						QC 3 - 36	
						QC 3 - 41	
						QC 3 - 51	
						QC 3 - 58	
						QC 3 - 59	
						QC 3 - 68	
						QC 3 - 9	
						QC 3 - 40	
						QC 3 - 19	
						QC 3 - 43	
						QC 3 - 24	
						QC 3 - 61	
						QC 3 - 81	
						QC 3 - 82	
						QC 3 - 87	
170	Packaging 3-1 - Stock - B4B	4 pcs	6/10/20	0.00	0.00	Packaging 3 - 1 - B4B	
						Packaging 3 - 2 - B4B	
						Packaging 3 - 3 - B4B	
						Packaging 3 - 4 - B4B	
						Packaging 3 - 5 - B4B	DAS
						Packaging 3 - 6 - B4B	28
						Packaging 3 - 7 - B4B	9-89

DAS
15
9-89

				Packaging 3 - 8 - B4B	
				Packaging 3 - 9 - B4B	
				Packaging 3 - 10 - B4B	
				Packaging 3 - 11 - B4B	
				Packaging 3 - 12 - B4B	
				Packaging 3 - 13 - B4B	
				Packaging 3 - 14 - B4B	
				Packaging 3 - 15 - B4B	
				Packaging 3 - 16 - B4B	
				Packaging 3 - 17 - B4B	
				Packaging 3 - 18 - B4B	
				Packaging 3 - 19 - B4B	
				Packaging 3 - 20 - B4B	
				Packaging 3 - 21 - B4B	
				Packaging 3 - 22 - B4B	
				Packaging 3 - 23 - B4B	
				Packaging 3 - 24 - B4B	
				Packaging 3 - 25 - B4B	
				Packaging 3 - 26 - B4B	
				Packaging 3 - 37 - B4B	
180 QC 21 - SA	4	6/10/20	0.00 0.00	QC 21 - SA - 21	JUN 03 2020 DAS
	pcs			QC 21 - SA - 70	70
				QC 21 - SA - 9	9-89

Part Op 100 - Cut blanks: (2.00" x 2.00") x 4.500" (+0.030/-0.00) Long Bar
 Descriptions: 110 - Machine per Folio FA318 and Dwg D3145 Deburr and Tumble
 120 - QC2- Inspect parts off machine FAI/FAIB
 130 - QC8- Inspect parts - second check
 140 - Chemical Conversion Coat per QSI005 4.1
 150 - White Gloss (Ref 4.3.5.1) per QSI005 4.3-Alum START TIME: 10:05 M254469 320°
 FINISH TIME: 10:35
 160 - QC3- Inspect Part Finish
 170 - Identify as per dwg & Stock Location: _____
 180 - QC21- Final Inspection - Work Order Release

CA002

Job BOM

Part / Item	Component Name	Quantity	Operation	Container
M6061T6B2.000X02.000	6061-T6 Bar 2.00 X 2.00	1.5332 ft (.3833 ea)	100-Bandsaw - 1	5250477

Job Allocations

Operation	Component Part	Required	Inventory	Allocated
100-Bandsaw - 1	M6061T6B2.000X02.000	2	20	0

Part Specifications					
Spec No	Description	Target/Tolerance	Limits	Type	Special Comments
1	Bracket	0.188inches $\pm$ 0.010	0.198 0.178	.188	Radius
2	Bracket	0.125inches $\pm$ 0.010	0.135 0.115	.130	
3	Bracket	1.636inches $\pm$ 0.010	1.646 1.626	1.642	
4	Bracket	0.125inches $\pm$ 0.010	0.135 0.115	.118	
5	Bracket	0.766inches $\pm$ 0.010	0.776 0.756	.766	
6	Bracket	0.250inches $\pm$ 0.010	0.260 0.240	.254	
7	Bracket	1.370inches $\pm$ 0.010	1.380 1.360	1.370	
8	Bracket	0.760inches $\pm$ 0.010	0.770 0.750	.760	
9	Bracket	4.303inches $\pm$ 0.010	4.313 4.293	4.301	
10	Bracket	0.125inches $\pm$ 0.010	0.135 0.115	.130	
11	Bracket	0.219inches $\pm$ 0.010	0.229 0.209	.210	
12	Bracket	0.125inches $\pm$ 0.010	0.135 0.115	.125	Radius
13	Bracket	1.960inches $\pm$ 0.010	1.970 1.950	1.960	
14	Bracket	1.250inches $\pm$ 0.010	1.260 1.240	1.250	
15	Bracket	0.180inches $\pm$ 0.010	0.190 0.170	.180	
16	Bracket	0.250inches $\pm$ 0.010	0.260 0.240	.250	Radius
17	Bracket	0.240inches $\pm$ 0.010	0.250 0.230	.235	
18	Bracket	0.108inches $\pm$ 0.010	0.118 0.098	.108	
19	Bracket	0.221inches $\pm$ 0.010	0.231 0.211	.221	Diameter
20	Bracket	0.351inches $\pm$ 0.010	0.361 0.341	.344	

Plex 5/22/20 12:51 PM Dart.lajeunesse.marie

Date: _____

WORK ORDER NON-CONFORMANCE / ROUTE UPDATE

NCR No.

Route update only

Job: _____ Part No. _____		DISPOSITION		DEPARTMENT/PROCESS	
Date : _____		Rework ☐ Scrap ☐ Use-as-is ☐		Skid-tube ☐ Machining ☐ Large Fab ☐	
Sequence #: _____		Cross tube ☐ Small Fab ☐ Finishing ☐		Eng. (Non-AW) ☐ Prod. Eng. Coord. ☐ Rec/Store/Packaging ☐	
QTY Affected : _____		Engineering ☐ Water Jet ☐ Supplier ☐ Quality ☐		MRB (QS1042)	
Description Work Order Deviation		Disposition		Completed By	
				Lead hand / Supervisor	
				QC / QA Coordinator	
Root Cause		FAULT CATEGORY			
Operator	Pressure/Forced	Contamination	Power Loss/Surge	Positioned Wrong	
Manufacturing Process	Bending	Misaligned/off center	Folio/Program	Outside Tolerance	
Equip/Tooling	Crushing	BOM/Route	Grain Direction	Drawing	
Handling/Preservation	Cracks	Broken/Damage/Defect	Weld	Finish	
Material	Crimp/Kink/Ripple/Wave/Twist	Incomplete/Unclear Instructions	Wrong Stock Pulled	Part Lost/Missing	
Product Improvement	Marks/Chatter	Drill Holes	Out of Sequence	Misread	
Process Improvement	Mislabeled	Fit/Function	Off-set/Set-up		
Human Factors	Other/Details:				